

Work Order ID 121463

Thursday, June 26, 2014 3:00:22 PM

121463

Page 1

Item ID: D4884-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: End Fitting, Eye
Start Date: 6/26/14 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 6/26/14 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: MLS Date: 14-06-27 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4884	REV A								

100 DOOSAN LATHE 0.00
100
Outsource5
Outsource process - Machining
Memo
ISSUE P.O: 27906
SUPLIER:ATG
C OF C IS REQUIRED

CX 14/07/08 16

110 ***110***
QC
Quality Control
Memo
QC2- Inspect parts off machine FAI/FAIB
QC6

120 ***120***
QC
Quality Control
Memo
QC8- Inspect parts - second check
N/A
15-01-07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Outsource process - NDT per QSI038 4.1	0.00							
130									
Outsource2	Memo	0.00							
Outsource process - NDT	ISSUE P/O : <u>24906</u>								
	C OF C IS REQUIRED								
140	Receive & Inspect for Damage & Mat'l Certs	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

CY 14107108

done @ ATG

16x 8015-017

16

DAS
38
9-89

IAN 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: ST129A	0.00							
160									
Packaging	Memo	0.00							DAS
Packaging	IDENTIFY AS PER QSI 044 6.1								06
									9-09
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

16 **JAN 07-2015** **DAS**

MLJ 15-01-08

15-1-8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ </td> <td style="width: 33%;"> Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width: 33%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 33%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐			

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Picklist Print

Thursday, June 26, 2014 3:00:22 PM

Page 1

Work Order ID: 121463

121463

Parent Item: D4884-3

D4884-3

Parent Item Name: End Fitting, Eye

Start Date: 6/26/14

Required Date: 6/26/14

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE 14-01-13 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4884-3P		Purchased		No			Each	0.0000		16			
D4884-3P									**				
End Fitting, Eye													
M174PH-H900R1.500		Purchased		No			f	31.8583		6			
M174PH-H900R1 500									**				
17-4SS H900 ROUND BAR 1.500													

Location

Loc Qty

Loc Code

MAT031

31.8583

M128809

31.8583

16 x SP 15-01-7.
14-7-10
DAS
13
6-26

6A+

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

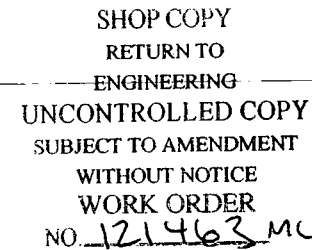
Work Order update only ☐

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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
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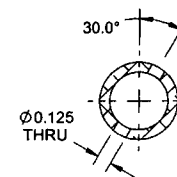
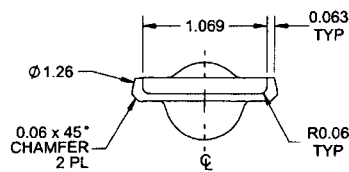
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other



Technical drawing of a mechanical part, likely a valve or fitting, showing dimensions and tolerances. The part has a cylindrical body with a flange on the left and a threaded section on the right. Key dimensions include: overall length 3.67, flange diameter 1.254, flange thickness 0.68, main body diameter 0.375 (tolerance 0.001), and a threaded section with a diameter of 0.30. The drawing also shows a transition with a radius of R0.25 and a taper with a radius of R0.63 TYP. A small dimension of 0.017 is shown at the bottom right.



Technical drawing of a circular part. The top view shows a circle with a central crosshair. A dimension line indicates a 30.0° angle. A hole is specified as Ø0.125 THRU.

NOTES:

- NOTES
- 1) MATERIAL: 17-4 PH/517400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.14 lbs
 - 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4884 TITLE END FITTING SCALE NTS DATE 13.12.01
	DRAWN	RF	
	CHECKED	DC	
	MFG. APPR.	JLM	
	APPROVED	HS	
	DE APPR.	DS	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24906

Purchase Order Date 7/8/2014

PO Print Date 8/20/2014

Page Number 4 of 8

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
51 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Total:

D4805-1P

End Fitting

12/19/2014 FN

20.00

\$138.00

Yes

Each

12/19/2014

AS PER DWG D4805-1 REV. A
R12146

SP14-12-16

Line Total:

D4920-1P

End Fitting

12/19/2014 FN

12.00

\$104.00

Yes

Each

12/19/2014

AS PER DWG D4920-1 REV. A
R12146
MATERIAL: 174PH-H900R 1.5" M128809

SP15-01-7

Line Total:

D4884-3P

End Fitting, Eye

12/19/2014 FN

16.00

\$122.00

Yes

Each

12/19/2014

AS PER DWG D4884-3 REV. A
R121463
MATERIAL: 174PH-H900R 1.5" M128809

SP15-01-7

Note:

8/20/2014



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 909409

Date: 07-Jan-15

To

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ship To

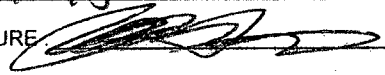
CHANTAL LAVOIE
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
12 ea	Part: D4920-1P END FITTING Job: 16645	Rev: A PO: PO24906 Line: 10	
16 ea	Part: D4884-3P END FITTING, EYE Job: 16646	Rev: A PO: PO24906 Line: 11	SP 15-01-7
18 ea	Part: D4920-3P END FITTING Job: 16651	Rev: A PO: PO24906 Line: 16	
DATE: 07/01/2015			
CERTIFIED SIGNATURE 			
RECEIVER SIGNATURE: _____			
Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
CERTIFICATE OF CONFORMANCE			
A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO THE REQUIREMENTS.			
MADE IN CANADA.			

SP 501-7.



F.A.I.

First Article Inspection Report

#

531

Requesting Company:	Dart Aerospace	PO#:	PO24906	Line:	11	Qty:	16
Part Number:	D4884-3P	Rev:	A	Part Description:	End Fitting, Eye		
FAI Supplied by:	A.T.G. Industries Inc.	FAI Prepared by:	Emily Louis-Seize	Date:	July 14, 2014		
Qty Inspected:	16	FAI Inspected by:	Mike Csontos	Date:	December 16, 2014		

Material and/or Special Processes

Type	Description	Specification Number/Code	Certificate of Conformance Number:
Material	17-4SS H900		Supplied by Customer
Special Process	Liquid Penetrant	QSI 038 6.1.1 (ASTM E1417 Level 2)	PO#: 20140525

Inspection Information and Results

Char#	Location	Requirement	Result	UoM	Pass/Fail	Measurement Equipment:	Operation #:
1	C7	Ø.500	Ø.502	inch	Pass	Gauge Pin	1
2	C7	1.17	1.172	inch	Pass	Depth Micrometer	1
3	C8	.09 REF	.096	inch	Pass	Depth Micrometer	1
4	D6	.68	.68	inch	Pass	Vernier Caliper	2
5	D5	2.060±.005	2.059	inch	Pass	Height Gauge	3
6	D5	R.25	R.25	inch	Pass	Radius Gauge	2
7	D5	.500	.500	inch	Pass	Height Gauge	3
8	D4	.030	.029	inch	Pass	Comparator	1
9	C4	.017	.017	inch	Pass	Comparator	1
10	C5	3.67	3.669	inch	Pass	Vernier Caliper	2
11	C5	R.63 TYP	R.625	inch	Pass	Comparator	1

Inspection Information and Results

Char#	Location	Requirement	Result	UoM	Pass/Fail	Measurement Equipment:	Operation #:
12	C4	1.83	1.831	inch	Pass	Vernier Caliper	2
13	C6	1.254	1.248	inch	Pass	Vernier Caliper	2
14	D6	Ø.375/.374	Ø.3745	inch	Pass	Gauge Pin	2
15	B7	1.069	1.067	inch	Pass	Vernier Caliper	2
16	B7	.063 TYP	.062	inch	Pass	Comparator	2
17	B7	R.06 TYP	.055	inch	Pass	Radius Gauge	2
18	B8	.06 x 45° Chamfer	.055 X 45°	inch/degree	Pass	Comparator	2
19	B8	Ø1.26	Ø1.26	inch	Pass	Vernier Caliper	1
20	B6	.200	.200	inch	Pass	Vernier Caliper	2
21	B4	Ø.670+.000/-.001	Ø.6695	inch	Pass	Micrometer	1
22	B5	1.39	1.387	inch	Pass	Vernier Caliper	2
23	B5	Note 6	D4884-3	n/a	Pass	Visual	3
24	B5	R.25 TYP	R.25	inch	Pass	Radius Gauge	2
25	B3	30°	30°	degree	Pass	Comparator	3
26	B3	Ø.125 thru	Ø.125	inch	Pass	Gauge Pin	3
27	B2	30°	30°	degree	Pass	Comparator	3
28	B1	Ø.125 thru	Ø.125	inch	Pass	Gauge Pin	3

First Article Inspection Report Approved and
Completed in Full by:

M. Cventy

Date:

6-Jan-15

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO23142	Customer: ATG Industries Inc	Dept: NDT YUL	Reference: 20140525
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

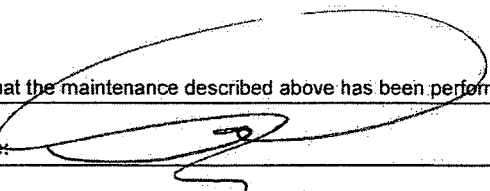
Work Required:

CARRY OUT NDT ON SEVENTY-FIVE PARTS AS PER PO :20140525

CLEVIS	P/N D4806-1P QTY:12
END FITTING	P/N D4920-1P QTY:12
END FITTING EYE	P/N D4884-3P QTY:16 ;
END FITTING	P/N D4885-5P QTY:6
END FITTING	P/N D4885-7P QTY:11
END FITTING	P/N D4920-3P QTY:18

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT AS PER ASTM E-1417M-13						JAN 06 2015	 
NO CRACK FOUND							
PEN.(ZL-37 , B#10A070), DEV.(SKD-S2,B#13D14k) , EMU.(ZR-10B,B#10A074).							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: JAN 06 2015
Name: RAFIK MELIKIAN		

SKYM002-1 REV 4 Mar/14

COPY